

Date: Tuesday, 03/06/2008 1:03:33 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPRING
 Job Number : 39670
 Estimate Number : 10497
 P.O. Number :
 This Issue : 03/06/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2535
 Drawing Number : D2535 REV. A
 Project Number : N/A
 First Issue : / / Type : PURCHASED PARTS Drawing Revision : A
 Material :
 Previous Run : 37071 Due Date : 10/06/2008 Qty: 100 Um: Each
 Written By :
 Checked & Approved By : JUL 08.6.03
 Comment : Est. A99.04.19 New Issue (From hand written IPP) DM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 649108/06/04

Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring

100

2.0 D2535P Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)
 SPRING

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached

08/06/12100

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK
 Check dims to dwg

08/06/12counted
100

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: 35

08/06/13100

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/06/2008 1:03:33 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING

Job Number: 39670

Part Number: D2535

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/16 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Cu 08-06-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

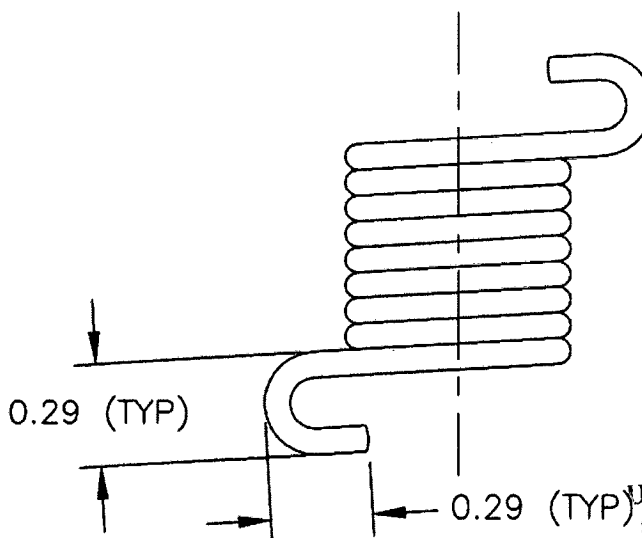
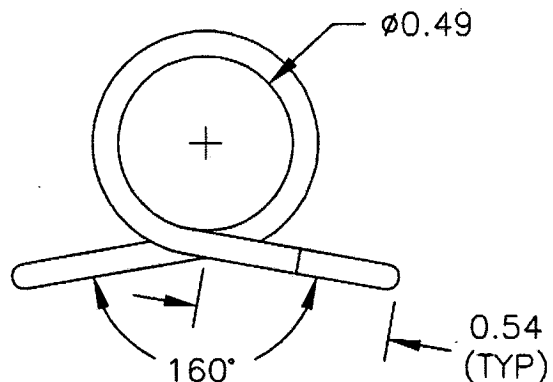
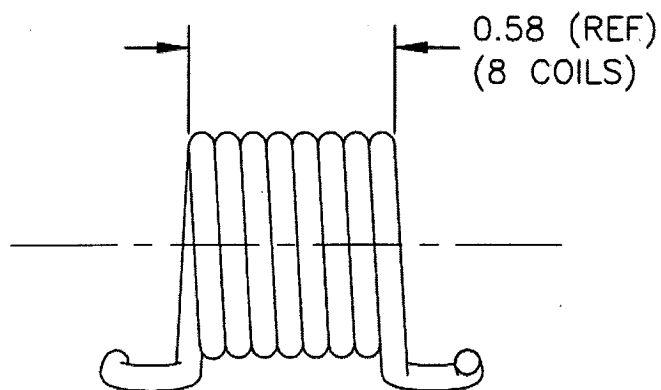
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED JA	DRAWING NO. D2535	REV. A SHEET 1 OF 1
DATE 99.04.08		TITLE SPRING SPEC CONTROL	SCALE 2:1
A	99.04.08	NEW ISSUE	

RELEASED
99.05.11 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31610

SPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)

MATERIAL: AISI STAINLESS STEEL $\phi 0.070$

POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



CONFORMANCE REPORT

#2. 6104 - 82 Ave, Edmonton, AB T6B 0E7
Tel: (780) 442-4020 Fax: (780) 466-8000

REPORT FOR: Dart Aerospace Ltd.		DATE: 6/11/2008
PO # 6491	PART/DRAWING #: D2535P	
SPRING DESCRIPTION: SS Torsion Spring		QUANTITY: 100

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS T302	Yes	
Material diameter	.070"	.072"	
I.D.	.490"	.485" / .493"	Min / Max
O.D.			
Number of Coils	8 Ref	Yes	
Free Length			
Helix	RHW	Yes	
End type	As per drawing	Yes	
Rate (lb/in)			
Finish			

COMMENTS

Mill Certificate attached: No
Material Heat Number: N/A

Certified by:

Jeremy Burrowes